

#4 B

Dart Aerospace Ltd.

Date: Thursday, 11/24/2005 12:13:27 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE  
 Job Number : 24960  
 Estimate Number : 10939  
 P.O. Number : N/A Part Number : D29382  
 This Issue : 11/24/2005 S.O. No. : N/A Drawing Number : D2938 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 11/24/2005 Type : MACHINED PARTS Drawing Revision : B  
 Previous Run : N/A Material : N/A  
 Written By : SEE COMMENT BELOW Due Date : 12/23/2005 Qty: 4 Um: Each  
 Checked & Approved By :  
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length (D6101-003) Batch No: <u>B24891</u> <u>JL 06/06/06</u> 4		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 5-Deburr <u>JL 06/06/06</u> 4		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <u>JL 06/06/06</u> 4		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET <u>JL 06/06/06</u> 4		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>JL 06/06/07</u> 4		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/06/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/24/2005 12:13:27 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 24960

Part Number: D29382

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*R-m*

*06-06-09*

*(4)*

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*FC*

*06 06 13*

*(4)*

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57476*

*Rec'd 11/4*

*(4)*

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/06/14*

*(4)*

Job Completion



*u 06-de-14*

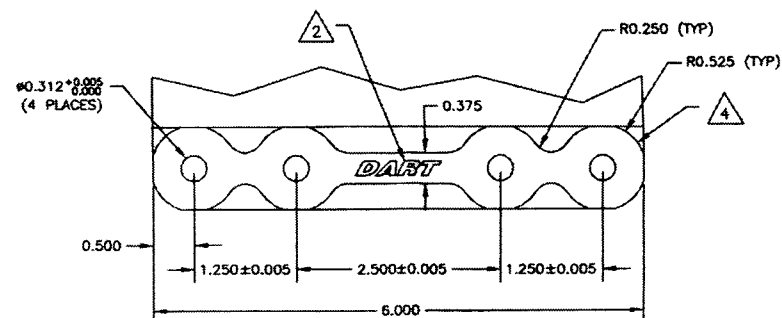
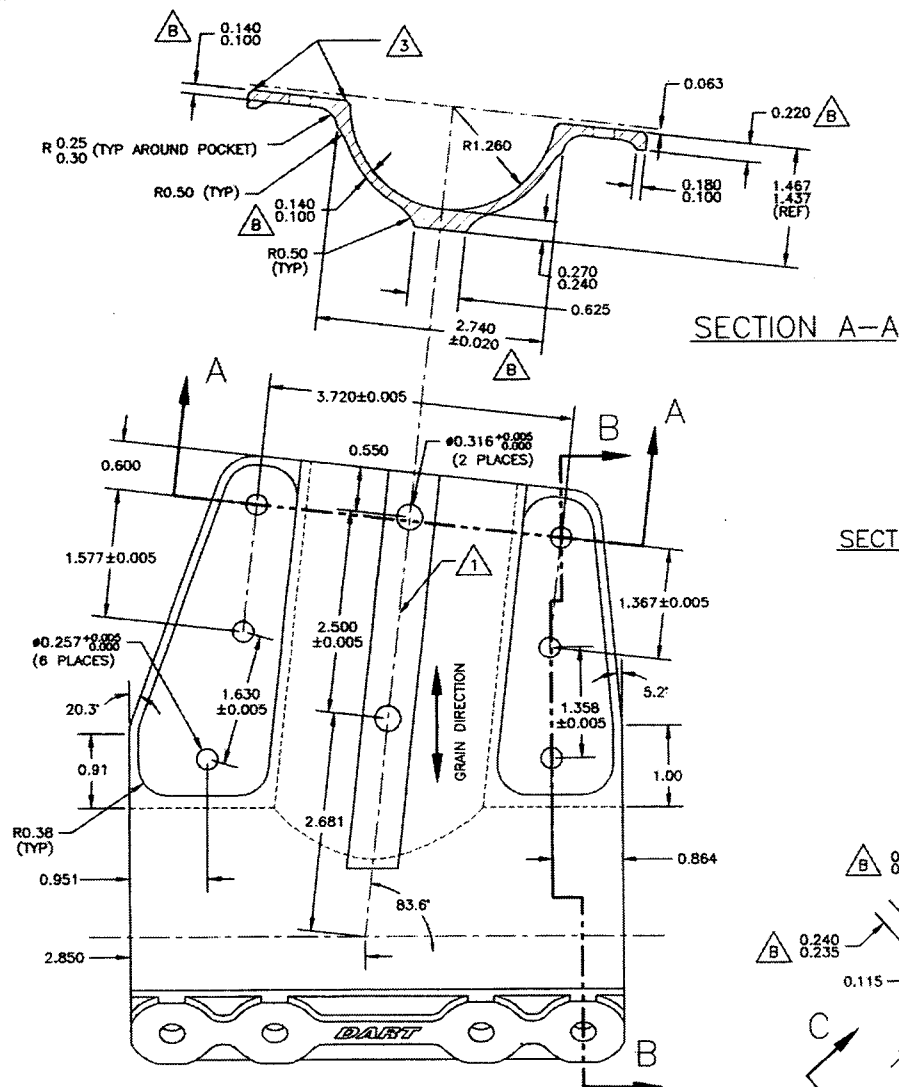
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

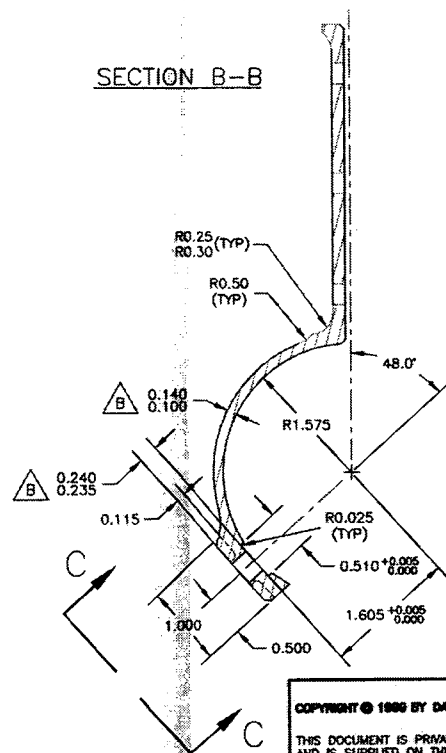
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLHUE, VA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	TITLE	REV. B SHEET 1 OF 1 SCALE 2:3
00.05.29	SADDLE OUTSIDE	

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DART AEROSPACE USA, INC.

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>
<b>Inspection Dwg:</b> D2938 Rev. B	<b>1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below

				Recorded Actual Dimensions				E	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.120	.115	.120	.121		
B	0.100	0.140		.118	.114	.119	.120		
C	0.100	0.140		.119	.113	.115	.115		
D	0.210	0.230		.215	.222	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.249		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.499		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.498	2.499		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.239	.238	.238	.239		
N	0.100	0.140		.112	.120	.121	.120		
O	0.540	0.560		.550	.548	.550	.549		
P	0.490	0.510		.502	.500	.498	.491		
Q	3.715	3.725		3.720	3.719	3.720	3.720		
R	2.720	2.760		2.750	2.750	2.750	2.750		
S	0.240	0.270		.250	.252	.260	.258		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.366	1.367	1.366	1.367		
W	0.316	0.321	DT8690						
X	1.250	1.270		1.260	1.267	1.263	1.262		
Y	1.565	1.585		1.573	1.580	1.576	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	06/06/06

Audited by:	gml
Date:	06/06/07

Rev	Date	Change	Revised
A		New Issue	RF
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF